

Date: Friday, 01/08/2008 3:32:42 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SLEEVE		
Job Number	: 40981		Part Number	: D37861		
Estimate Number	: 13330		Drawing Number	: D3786 REVA		
P.O. Number	:		Project Number	: N/A		
This Issue	: 01/08/2008 S.O. No. :		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : MACHINED PARTS		Due Date	: 21/08/2008 Qty: 30 Um: Each		
Previous Run	: 40318					
Written By	:					
Checked & Approved By	: <u>JUL 09, 8.05</u>					
Comment	: Est Rev:A 08-05-20 new issue DD verified by:EC					
	Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
	Comment: Qty.: 0.1750 f(s)/Unit Total : 5.2511 f(s) 6061T6 TUBE batch: <u>108819</u>	<i>PL 08/08/08</i>
2.0	DOOSAN LATHE	DOOSAN LATHE
	Comment: DOOSAN LATHE	
	1- Turn as per Folio FA747 Rev: <u>A</u> & Dwg D3786 Rev: <u>A</u>	
	2-Deburr per dwg D3786	<i>20 08/08/08</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>PL 08/08/08 30</i>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>PL 08/08/08 30</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>PL 08/08/11 30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

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Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 40981

Part Number: D37861

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(30x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.F. 08/08/11

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(50x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *8/8/11*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

Done 08/08/11

Job Completion



M.F. 08-08-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40981
Description: Sleeve	Part Number:	D3786-1
Inspection Dwg: D3786	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

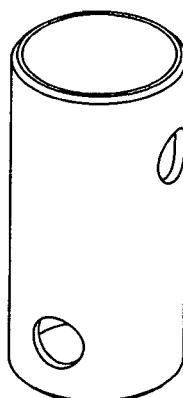
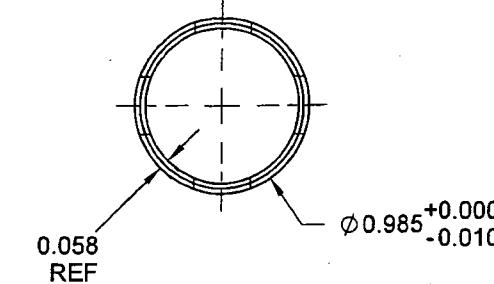
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08/08/06	Date:	08/08/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.25	New Issue	KJ/DD	

8 7 6 5 4 3 2 1

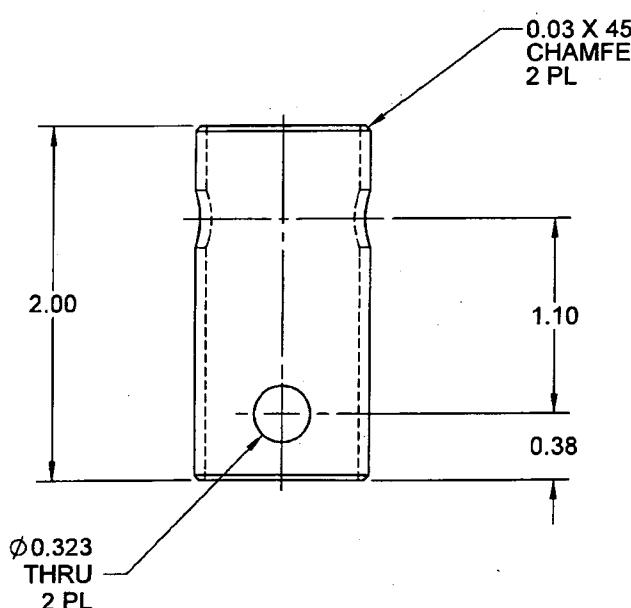
D

D



C

C



B

B

D3786-1 SLEEVE

A NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000 X 0.065 WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

8 7 6 5 4 3 2 1

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PJ</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JL</i>	D3786	SHEET 1 OF 1
APPROVED	<i>JL</i>	TITLE	SCALE
DE APPR.	<i>JL</i>	SLEEVE	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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08.06.04

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WORK ORDER
NO. *40981*